

Date: Friday, 7/21/2006 1:55:02 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	28025	Part Number	: D2596		
Estimate Number	10346	Drawing Number	: D2596 REV C		
P.O. Number	N/A	Project Number	: N/A		
This Issue	7/21/2006	S.O. No.	: N/A		
Prsht Rev.	NC	Drawing Revision	: C		
First Issue	N/A	Material	: N/A		
Previous Run	27655	Due Date	: 7/31/2006		
Written By	Step <u>1</u> Comment Below				
Checked & Approved By	: 06.07.21				
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D25003100	Extr'n "I" Beam Web 4"			
					
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion B25751 <i>IT 06-08-11</i> (12)					
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1			
					
<b>Comment:</b> LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" <i>IT 06-08-11</i> (12) 2- Use Jig DT8093 to drill pilot holes #30 <i>IT 06-08-14</i> (12) 3- Open to 0.625" diameter using a uni-bit <i>IT 06-08-14</i> (12) 4- Deburr <i>IT 06-08-14</i> (12)					
3.0	HAND FINISHING 1	HAND FINISHING RESOURCE #1			
					
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 <i>IT 06-08-14</i> (12)					
4.0	QC5	INSPECT WORK TO CURRENT STEP			
					
<b>Comment:</b> INSPECT WORK TO CURRENT STEP <i>Pm 06-08-14 (12)</i>					
5.0	PACKAGING 1	PACKAGING RESOURCE #1			
					
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: LG <i>Pm 06-08-14 (12)</i>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 NoDQA: Date: 06/08/15

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 28025

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(12)



06/08/15

Job Completion



u 06/08/15

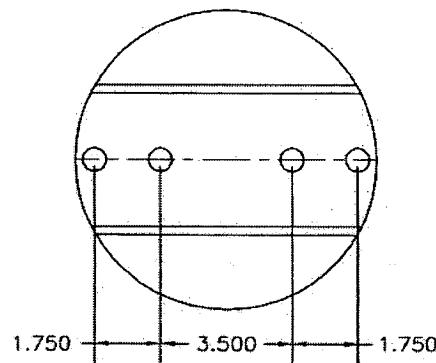
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DETAIL A  
SCALE 5:24



1.750 3.500 1.750

\$0.63 (TYP)  
(20 PLACES)

REFER TO D

UNCONTROLLED COPY  
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WITHOUT NOTICE

SHOP COPY  
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ENGINEERING

MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER  
NO. 28025

OBJECTION WITHOUT NOTICE

UNCONTROLLED COPY  
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SHOP CRAFT  
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Technical drawing showing a horizontal structure with various dimensions and a circular feature. The drawing includes the following dimensions:

- Vertical height: 8.750
- Vertical height: 17.375
- Vertical height: 26.000
- Vertical height: 34.188
- Horizontal distance from left edge to vertical line: 0.50
- Horizontal distance between vertical lines: 1.750
- Horizontal distance between vertical lines: 1.750
- Horizontal distance from center of circular feature to right edge: 0.50 (REF)
- Total width: 91.500
- Total width: 99.50

Annotations include:

- $\phi 0.63$  (TYP)  
(20 PLACES)
- 57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH
- REFER TO DETAIL A

CHECKED <i>BB</i>	APPROVED <i>SG</i>	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	REV. C
DATE 98.09.14	TITLE 205 WEB	SHEET 1 OF 1	SCALE 1:24
A	96.09.16 NEW ISSUE		
B	97.07.23 Ø0.63 HOLE WAS Ø0.56		
C	98.09.14 INCORPORATED DEO 9097		